

SPLIT

Date: Wednesday, 12/20/2006 11:59:11 AM  
 User: Kim Johnston

## Process Sheet

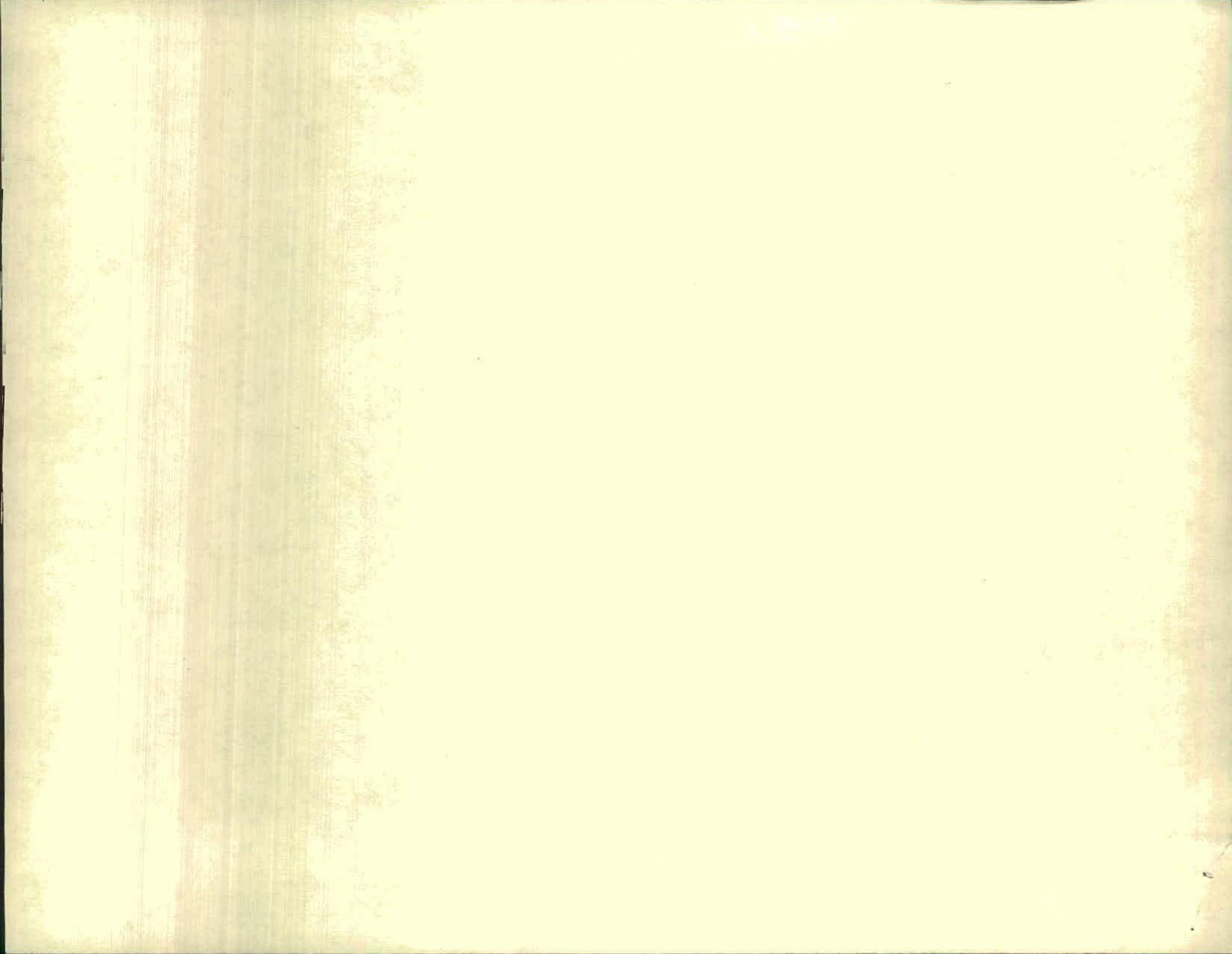
Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	WEARPLATE		
Job Number	29994			Part Number	D25771		
Estimate Number	10288			Drawing Number	D2577 REV E		
P.O. Number	N/A			Project Number	N/A		
This Issue	12/20/2006 S.O. No. N/A			Drawing Revision	E		
Prsh Rev.	NC			Material	N/A		
First Issue	N/A			Due Date	1/10/2007		
Previous Run	29488			Qty:	40	Um:	Each
Written By							
Checked & Approved By							
Comment	Est: E 02.09.24 Re-format; Incorporated D2577 101/11KJ/ RF est F 06.09.11 now waterjet EC						

## Additional Product

Job Number:

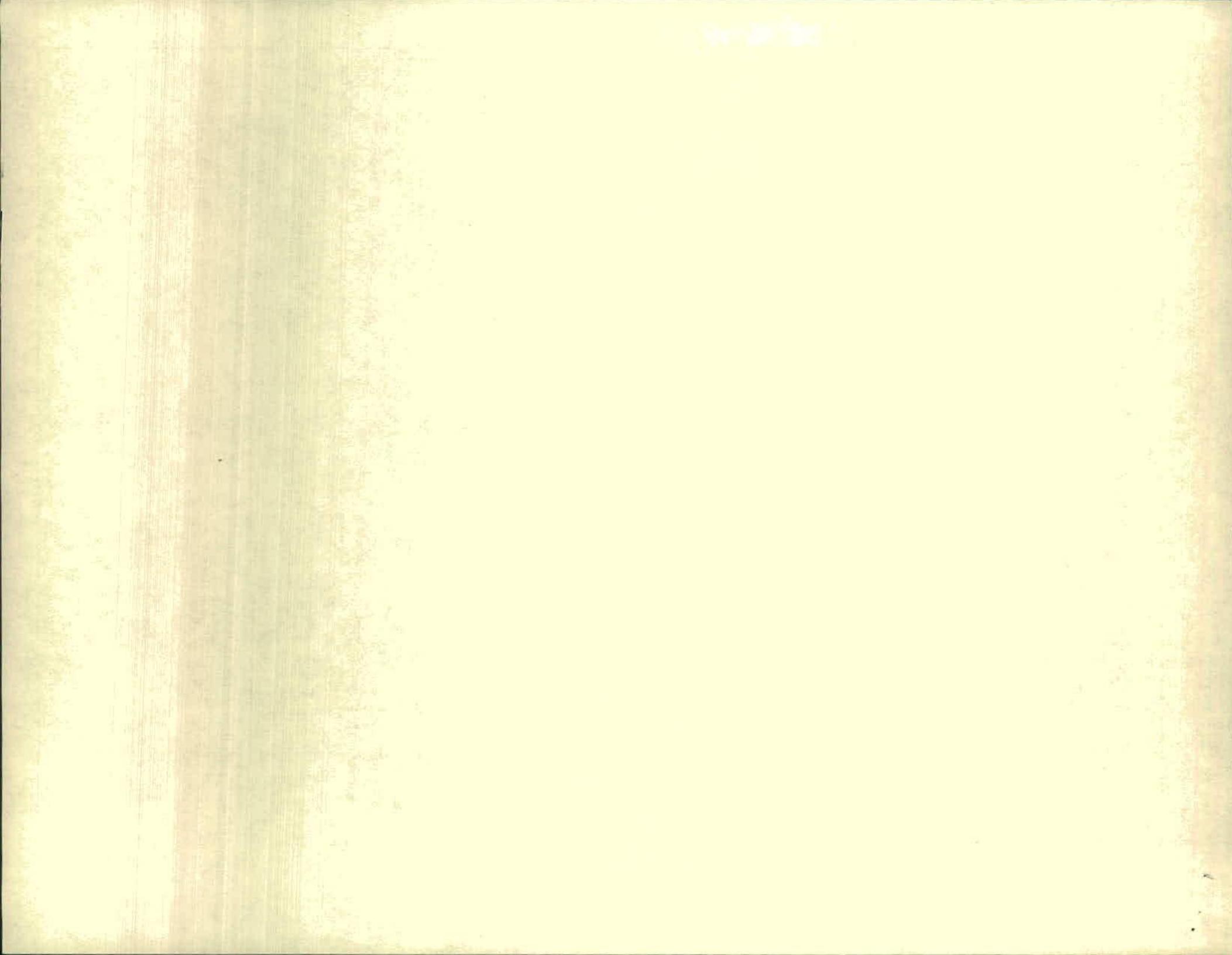


Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		 Comment: Qty.: 0.8474 sf(s)/Unit Total: 33.8940 sf(s) 1010/1025/A21/6aA SHEET <i>A103188</i>
2.0	WATER JET	 Comment: FLOW WATER JET ✓ 1-Cut as per Dwg D2577 (D2577-101 detail) Dwg Rev: <i>E</i> <i>ML 07 03 15</i> Prog Rev: <i>E</i>
3.0	QC2	 Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>ML 07 03 15</i>
4.0	QCB	 Comment: SECOND CHECK
5.0	BRAKE NC	 Comment: NC BRAKE
		Comment: NC BRAKE 1-Form on brake as per Dwg D2577 using DT8155 and DT8179 2-Form joggle as per Dwg D2577 using DT8157 3-Identify as D2577-1 4-Deburr if necessary <i>MF 07 03 23</i> <i>ST 07 103126</i> <i>SB 07 103122</i>

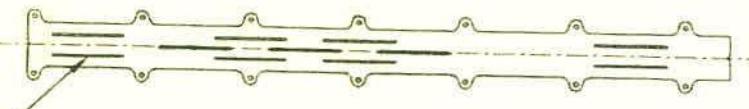


## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPLATE
Job Number: 29994	Part Number: D25771	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		M07/03/26
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 Weld hard surface using DT8308A & DT8308B as per Dwg D2577		FC 07/03/29 (IV)
Qty A/R	Description 7560 Hardcoat Rod	Batch M103372
8.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		M07/03/29 (II)
9.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		M101601 07/03/29 (II)
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		M-H 07/03/29 (III)
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP		07/03/29 (II)
12.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		07/03/30 (II)
Job Completion	 W 07.03.29	



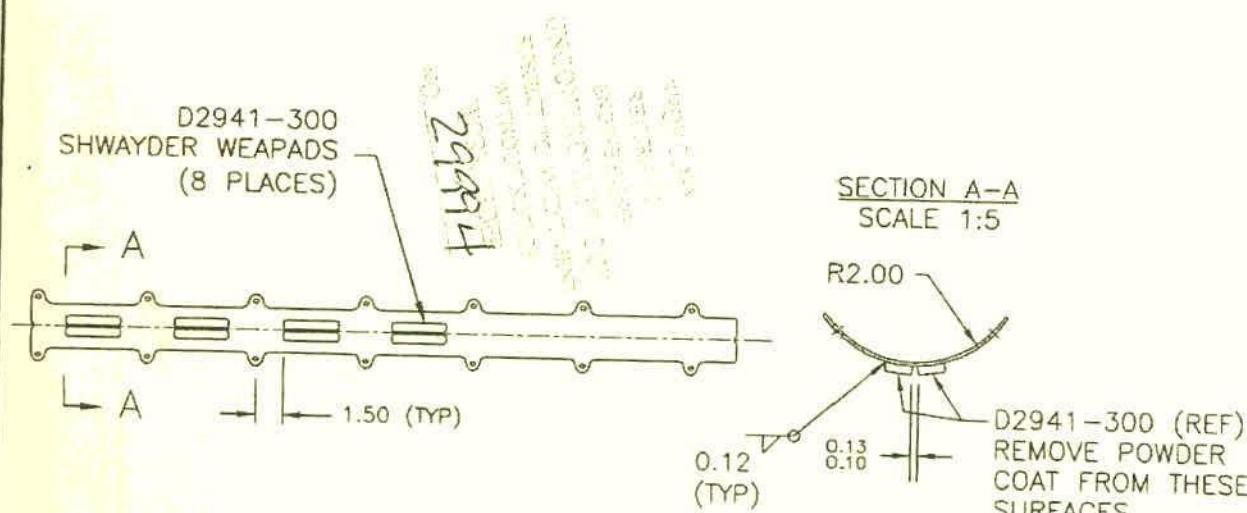
7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

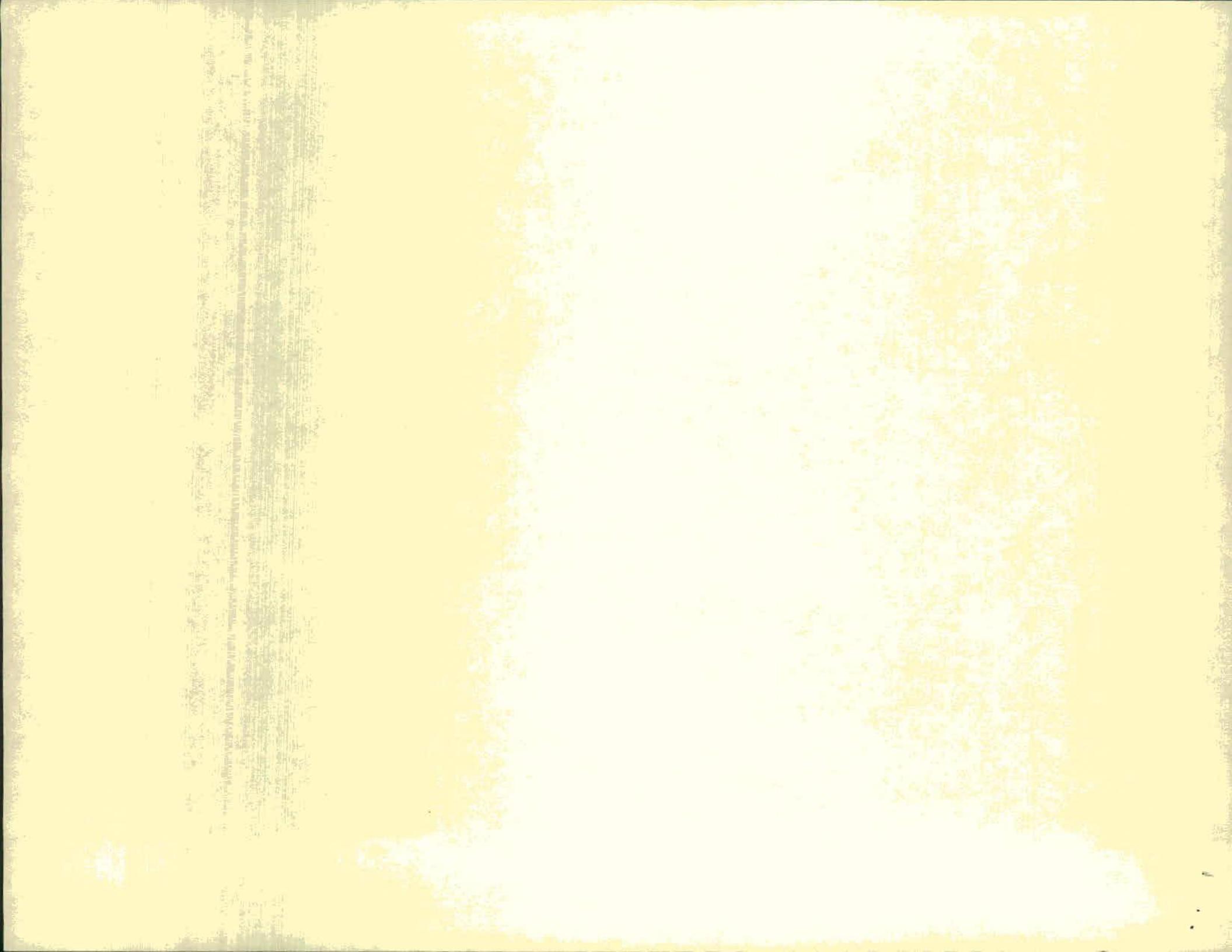
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
*On 04/26/97*

**DART**

*ON APPROVAL*  
*Design*

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO. HAWKESBURY, ONTARIO, CANADA
DATE		REV. E
00.09.22		SHEET 1 OF 5
A	96.09.16	SCALE 1:10
B	96.12.04	NEW ISSUE
C	97.05.30	ADD HARDCOAT WELDS
D	98.08.17	CHANGE HOLES TO OBOUNDS
E	00.09.22	INCORPORATE DE09176 ADDITIONS D2577-101/-11/-13 DE09176



ART AEROSPACE LTD	Work Order:	29994
Description: Wearplate	Part Number:	D2577-1
Inspection Dwg: D2577 Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Inspired by per template D2577 = $\frac{1}{3}$		✓			
B						
C						
D						
E						
F						
G						
H						
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O						
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X						
Y						

Measured by:	<i>John J. Hart</i>
Date:	07/03/15

Audited by:	<i>A</i>
Date:	07/03/19

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

